

Date: Wednesday, 1/25/2006 1:18:41 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 25613A		
Estimate Number	: 10206		
P.O. Number	: N/A	Part Number	: D2989041
This Issue	: 1/25/2006 S.O. No. :N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 25612A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 2/16/2006
Checked & Approved By	: <u>06.01.27</u>	Qty:	1
Comment	: Est Rev:l Removed D2989-043 05-11-03	Um:	Each
JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty.(1) D3166-3 Batch: <u>B25508</u>	<u>PD</u> 06-02-14
2.0	D2581	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part number Description Batch 2 D2581 Mounting Brackets <u>B25135</u>	<u>PD</u> 06-02-16
3.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part number Description Batch 2 D2327-3 Bushing <u>B24874</u>	<u>PD</u> 06-02-16
4.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part number Description Batch 1 D2506 Label Plate <u>B24875</u>	<u>PD</u> 06-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:18:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 25613A

Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number Description Batch
15sf M304EX0.75-16F Expanded Metal M100071

PD

06-02-16

6.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: SM100023

PD

06-02-16

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989Identify as D2989-041

PD

06-02-23

8.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DL 06/02/23

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

DL 06/02/25

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M19640

Wing Walk: M10037

M 06-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:18:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 25613A

Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



J 06/02/27

Comment: Inspect Powder Coat and Wing Walk

11.0 DC

DOCUMENT CONTROL



(D)

Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/02/28

Job Completion



U 06-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY		SCALE NTS
A	00.10.27 NEW ISSUE		
B	05.06.07 ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS		

RELEASED

05-08-19

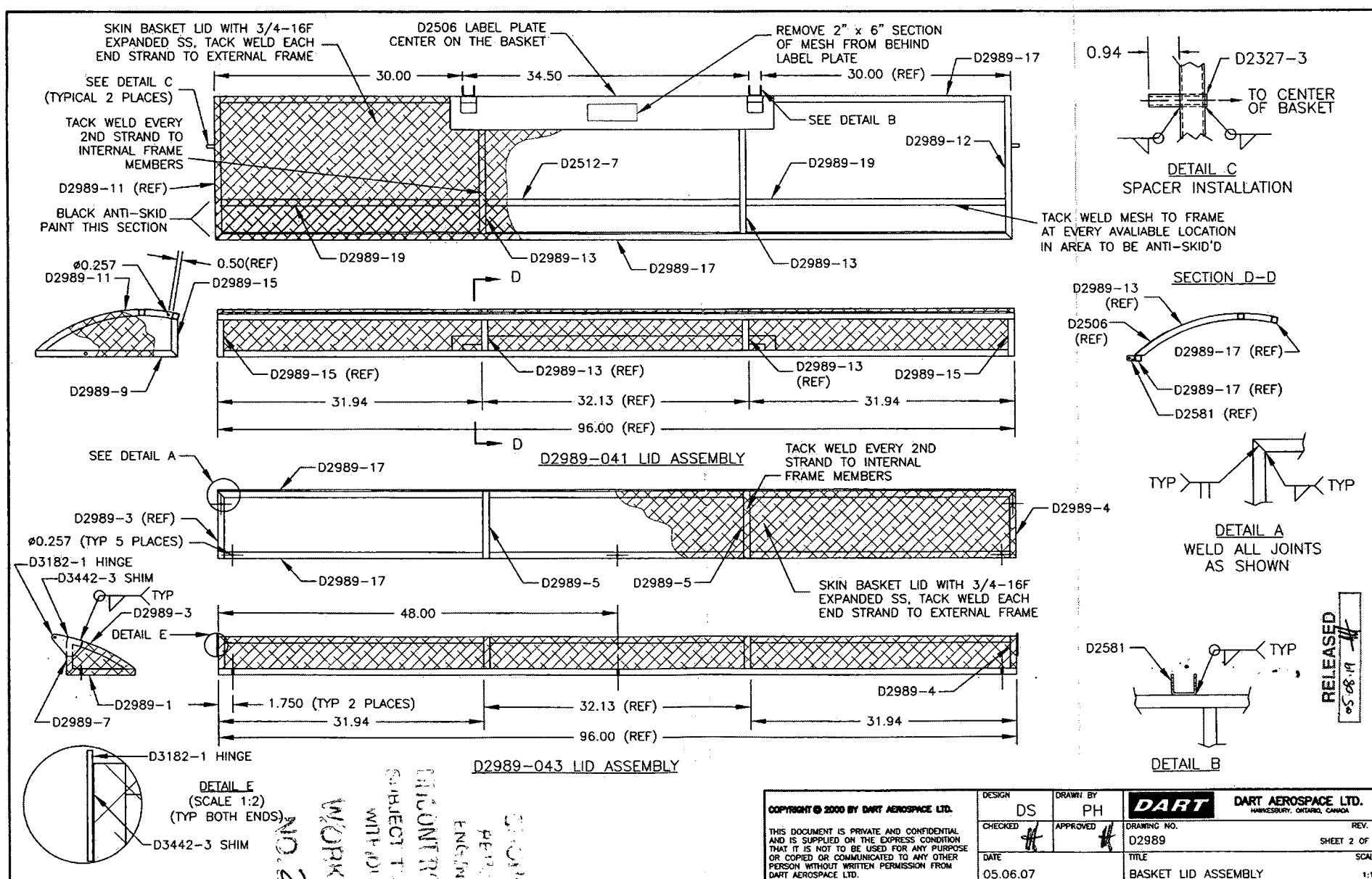
PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDERS
NO 25613 A



COPYRIGHT © 2000 BY DART AEROSPACE LTD.

This document is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without written permission from Dart Aerospace Ltd.

